

ASTP

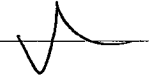
Work Order ID 109900

109900

Page 1

December-05-13 11:00:00 AM

Item ID: D4910-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Chaffing Shield
Start Date: 12/05/13 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 12/13/13 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4910	A								
100	SHEAR	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
304 24GA	Dwg Rev: A								
(0.025")	Prog Rev: A								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

4 0 Jm14-1-5

4 0 Jm14-1-5

Work Order ID 109900

109900

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December-05-13 11:00:00 AM

Item ID: D4910-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Chaffing Shield
 Start Date: 12/05/13 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 12/13/13 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 27 9-89 14/1/8				4			
130 *130* Small Fab Small Fab	Small Fab Memo 1- Roll as per Dwg 2- Apply a thin coat of proseal as per dwg and let cure.	0.00 0.00				4			14/01/09 DAS 36 9-89
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4			14-1-11 DAS 05 14-01-13

Work Order ID 109900***109900***

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December-05-13 11:00:00 AM

Item ID: D4910-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Chaffing Shield

Start Date: 12/05/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/13/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: L653

0.00

150

Packaging

Memo

0.00

Packaging

4 0 0 AS
14-1-13

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

PL 14-01-1314-01-13

Picklist Print

December-05-13 10:59:59 AM

Page 1

Work Order ID: 109900

Parent Item: D4910-1

Parent Item Name: Chaffing Shield

Start Date: 12/05/13

Required Date: 12/13/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.08.21 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S25GA
304/316 020" Sheet

Purchased

No

100

sf

0.0000

0.35

2

JM14-1-5

M304S24GA

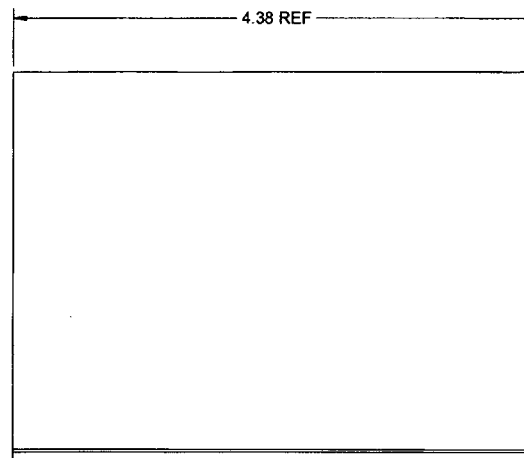
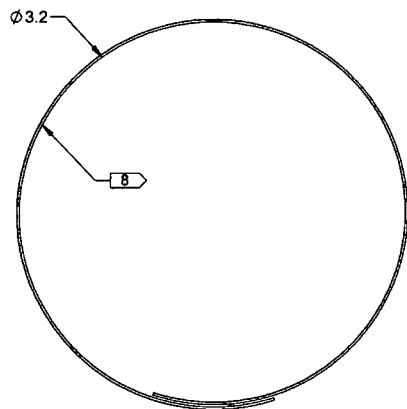
M304S24GA MTL

ACCEPTABLE A.P.

14.01.08

B# 125771

125771



D4910-1 CHAFING SHIELD

NOTES:

- 1) MATERIAL: MAKE FROM D4910-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs
- 8) APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D4910-1 CHAFING SHIELD AND LET CURE PER MANUFACTURER'S INSTRUCTIONS.

W/0 bag

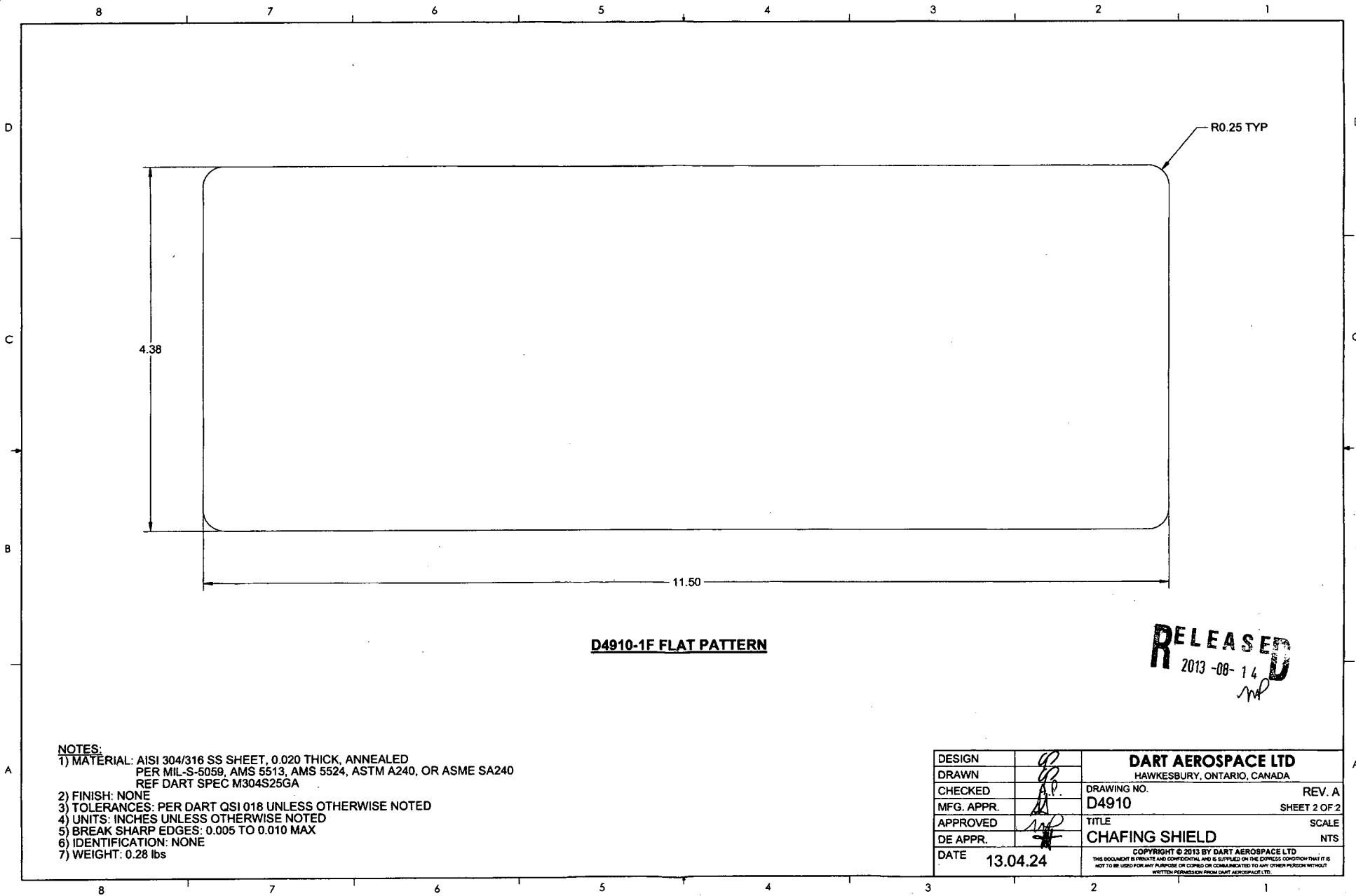
RELEASED
2013-08-14

A	NEW ISSUE	CP	13.04.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.04.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4910** REV. A
SHEET 1 OF 2
TITLE **CHAFING SHIELD** SCALE NTS

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D4910-1F FLAT PATTERN

RELEASED
2013-08-14
sm

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.020 THICK, ANNEALED
PER MIL-S-5059, AMS 5513, AMS 5524, ASTM A240, OR ASME SA240
REF DART SPEC M304S25GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>GP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>GP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>GP</i>	D4910	SHEET 2 OF 2
APPROVED	<i>GP</i>	TITLE	SCALE
DE APPR.	<i>GP</i>	CHAFING SHIELD	NTS
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